

Work Order ID **94332*****94332***

Page 1

Friday, December 07, 2012 2:16:01 PM

Item ID: **DSI 9638-011**

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Engine Mount Upgrade

Start Date: 12/7/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/13/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *12-12-09* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9638	A								
100		<i>JB</i>							<i>MCJ 12-12-11</i>
100	DOCUMENT CONTROL	0.00							
DC		0.00							
Document Control	Memo								
	Photocopy bluefile & type labels per PPP DSI9638-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging		0.00							
Packaging	Memo								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC		0.00							
Quality Control	Memo								

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 94332

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94332

Page 2

Item ID: DSI 9638-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Engine Mount Upgrade

Stop ***NS2***

Start Date: 12/7/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/13/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9638-011								
	Location: <u>PG032</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(100)

SL

12/12/12

DAS
20
2-8

MLJ 12-12-12

MF
12-12-12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

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		<input type="checkbox"/> Other

Picklist Print

Friday, December 07, 2012 2:16:01 PM

Page 1

Work Order ID: 94332

Parent Item: DSI 9638-011

Parent Item Name: Engine Mount Upgrade

Start Date: 12/7/2012

Required Date: 12/13/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.12.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

HL32PB8-11

Pin

SMB 6x

Purchased

No

Location

Loc Qty

Loc Code

ST284

54

123916

54

123916

HL32PB8-14

Pin

SMB 6x

Purchased

No

Location

Loc Qty

Loc Code

ST284

598

123916

598

123916

HL86-8

Collar

SMB 6x

Purchased

No

Location

Loc Qty

Loc Code

ST284

456

123916

456

123916

08-550

Drill Bit

SMB 6x

Purchased

No

Location

Loc Qty

Loc Code

ST284

27

123953

27

123953

13-420

Piloted Drill

SMB 6x

Purchased

No

Location

Loc Qty

Loc Code

ST284

20

123953

20

123953

44-300

Step Reamer

SMB 6x

Purchased

No

Location

Loc Qty

Loc Code

ST284

18

123953

18

123953

12/12/11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-770 REV. C
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-770 REV. 2

REF. TCCA STC: SH08-8

REF. FAA STC: SR02690NY / SR02070SE

REF. EASA STC: EASA.IM.R.S.01528

1.0 PURPOSE

On D205-770-011 Replacement Engine Mount Kits at CHG 006 or later, the AN3C12A Bolts, D3692-1 Spacers, and MS21043-3 Nuts on the upper and lower ends of each leg are replaced with HL32PB8-11/-14 Hi-Lok Pins and HL86-8 Hi-Lok Collars to prevent premature loosening and/or bolt failure in service. The adhesive used to assemble the rod end bearings has also been changed from Sikaflex-291/Proseal 890 to Hysol 934NA or Magnabond 6398. Customers with D205-770-011 Replacement Engine Mount Kits at CHG 005 or earlier are encouraged to procure the DSI 9638-011 Kit from Dart to upgrade their existing kits. Note: this service instruction supersedes DSI 9571.

2.0 INSTALLATION

- 2.1 Remove the engine mounts from the aircraft per ICA-D205-770. Inspect D3693-1 Rod End Bearings for play and for suitability for continued service. Replace if required.
- 2.2 Remove qty(1) AN3C12A Bolt from each end of each engine mount leg. Ensure holes are not elongated more than 0.030". If holes are elongated by more than 0.030", then parts will need to be replaced.
- 2.3 Clean each hole using drill bit P/N 08-550.
- 2.4 Enlarge each hole using Piloted Drill P/N 13-420.
- 2.5 Ream each hole to Ø0.248 using Step Reamer P/N 44-300.
- 2.6 Install an AN4-12A Bolt and MS21042-4 Nut in each reamed hole and tighten.
- 2.7 Remove remaining AN3C12A Bolts and repeat steps 2.2 through 2.4.
- 2.8 Mark each end of the legs to ensure all parts will be re-assembled in original location and orientation.
- 2.9 Disassemble engine mounts, de-burr, and clean all parts making sure to remove all traces of existing sealant while keeping intact the markings performed at Step 2.8.
- 2.10 Re-assemble engine mounts using Hysol 934NA or Magnabond 6398 adhesive and P/N HL32PB8-11/-14 and HL86-8 Hi-Lok fasteners.
- 2.11 Re-install engine mounts in the aircraft per ICA-D205-770.

3.0 PARTS LIST

Qty -011	Part Number	Description
X	DSI 9638-011	UPGRADE KIT
2	HL32PB8-11	HI-LOK PIN
22	HL32PB8-14	HI-LOK PIN
24	HL86-8	HI-LOK COLLAR
1	08-550	DRILL BIT
1	13-420	PILOTED DRILL
1	44-300	STEP REAMER

4.0 WEIGHT & BALANCE

This change has negligible effect on weight and balance.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.11.27
CERT. NO.: SH08-8
ISSUE NO.: 1

A	NEW ISSUE	MB	12.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9638	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ENGINE MOUNT UPGRADE KIT	NTS
DATE	12.11.26	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			